



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7401
Job Sheet 175474



Part No: 647.7401

Job Qty: 1 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Stores/Pkg-1		APR 06 2018
110	Packaging	1 pcs	4/12/18	4/12/18	0.00	0.00	Packaging1-1		APR 06 2018
120	Small Fab	1 pcs	4/13/18	4/13/18	0.00	1.09	Small Fab-1		
130	QC	1 pcs	4/13/18	4/13/18	0.00	0.00	QC5		
140	Packaging	1 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3-1		APR 11 2018
150	QC21-SA	1 Ea	4/13/18	4/13/18	0.00	0.00	QC21		

Part Op 120 - Assemble as per dwg and apply locite 598 on all faying surfaces per note 2. A/R RTV LOCTITE
Descriptions: 598: _____ exp. date: _____

140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	504333b
647.7610	Upper Deflector	1 Ea (1 ea)	90-Start up Operation	138533
647.7810	Bracket A	1 Ea (1 ea)	90-Start up Operation	5047608
647.7811	Bracket B	1 Ea (1 ea)	90-Start up Operation	80 47633
647.7812	Center Plate, Upper	1 Ea (1 ea)	90-Start up Operation	5032493
MS21042L08	Use Ms21042L08	13 Ea (13 ea)	90-Start up Operation	5040234
MS21042-3	Nut	3 Ea (3 ea)	90-Start up Operation	5027548
MS27039-08-19	Screw	6 Ea (6 ea)	90-Start up Operation	5027548
MS27039-08-23	Screw	7 Ea (7 ea)	90-Start up Operation	50173323-0
MS27039-1-19	Screw	3 Ea (3 ea)	90-Start up Operation	5030031
NAS1149F0332P	Washer	6 Ea (6 ea)	90-Start up Operation	5057525
NAS1149FN832P	Washer	68 Ea (68 ea)	90-Start up Operation	5020004



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S058715



Part: 647.7401

Job No: 175474

Serial No/Batch: S058715

Revision:

Inspector:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	2	2	0
	647.7610	1	3	0
	647.7810	1	2	0
	647.7811	1	6	0
	647.7812	1	5	0
	MS21042-08	13	0	0
	MS21042-3	3	266	0
	MS27039-08-19	6	2,030	0
	MS27039-08-23	7	37	0
	MS27039-1-19	3	286	0
	NAS1149F0332P	6	3,403	0
	NAS1149FN832P	68	3,608	0
Part Specifications				
Specifications could not be found.				

Plex 4/5/18 9:51 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					